

Date: Tuesday, 7/10/2007 1:06:07 PM
User: Kim Johnston

29

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABIN FLOOR PROTECTOR KIT
Job Number : 33459	
Estimate Number : 12936	
P.O. Number : <i>N/A</i>	Part Number : D412760011
This Issue : 7/10/2007 S.O. No. : <i>N/A</i>	Drawing Number : <i>N/A</i>
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 33346	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/17/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : est rev A 07.07.05 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-760-011 CHG001

[Handwritten initials and circled 1]

2.0	PACKAGING 1	PACKAGING-RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D35741	CABIN FLOOR PROTECTOR
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CABIN FLOOR PROTECTOR

batch: *33356*

4.0	D35742	CABIN FLOOR PROTECTOR
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CABIN FLOOR PROTECTOR

batch: *33357*

5.0	D35751	CABIN FLOOR PROTECTOR
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CABIN FLOOR PROTECTOR

batch: *33358*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:06:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR KIT

Job Number: 33459

Part Number: D412760011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35752

CABIN FLOOR PROTECTOR



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CABIN FLOOR PROTECTOR

batch: 33359

7.0

D35801

JOGGLE BRACKET



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

JOGGLE BRACKET

batch: 63345

8.0

D36281

CUPPED WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

CUPPED WASHER

batch: 633443

9.0

D36283

CUPPED WASHER



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

CUPPED WASHER

batch: 633444

10.0

MS24694S54

Screw



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Screw

batch: M9599

11.0

MS24694S100

FLAT HEAD SCREW



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

FLAT HEAD SCREW

batch: M18431

12.0

AN960JD10

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch: M104517

EP57/07/110

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 21/07/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:06:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR KIT

Job Number: 33459

Part Number: D412760011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M104215- ✓

EF 5/10/13 (1)

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/17/13 (1) 070707113(1)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-760-011

Location: _____

PPP Rev: _____

07/17/13 (1)

Job Completion



QC21 Final inspection w/o release 07/07/13

u 07/07/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

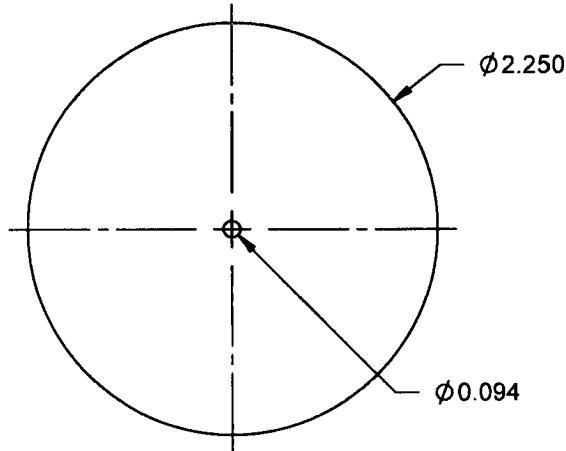


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D3628	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE CUPPED WASHER	SCALE 1:1
REV	DATE	DESCRIPTION	
A	07.06.08	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

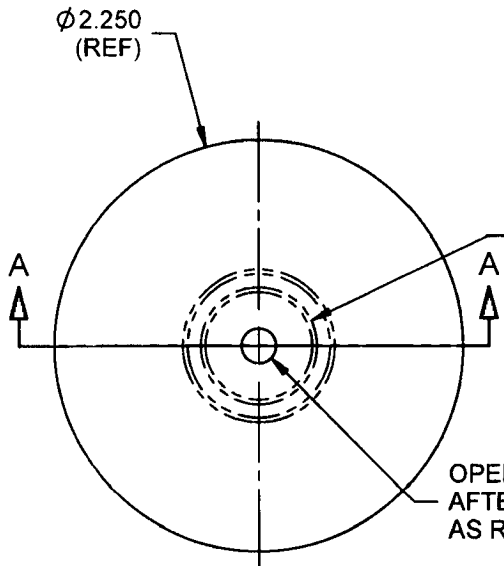
RELEASED

07.07.09 **[Signature]**

REFERENCE ONLY



D3628-1F FLAT PATTERN



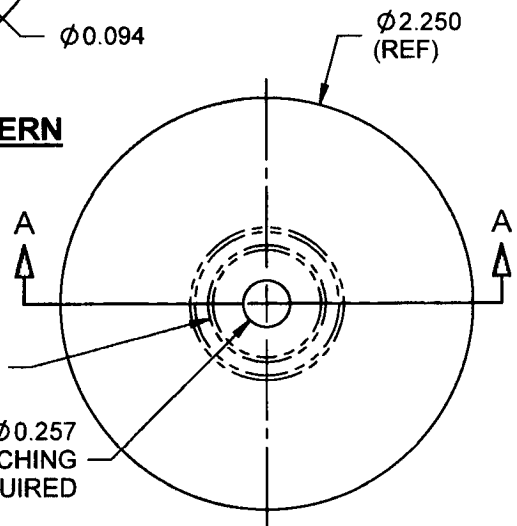
D3628-1 CUPPED WASHER
(MAKE FROM D3628-1F)

PUNCH $\phi 0.64 \times 0.16$ DEEP

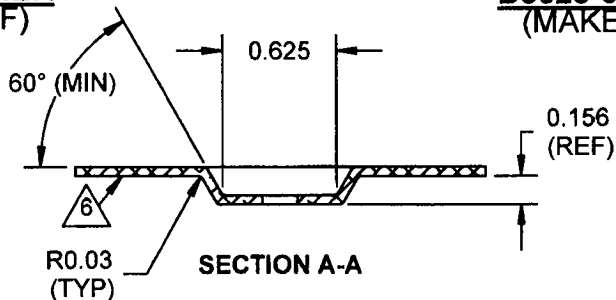
PUNCH $\phi 0.64 \times 0.16$ DEEP

OPEN TO $\phi 0.191$
AFTER PUNCHING
AS REQUIRED

OPEN TO $\phi 0.257$
AFTER PUNCHING
AS REQUIRED



D3628-3 CUPPED WASHER
(MAKE FROM D3628-1F)



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03

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